

Work Order ID 83304

83304

Page 1

April-17-12 8:48:52 AM

Item ID: D2597

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 204 Web

Stop ***NS2***

Start Date: 17/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/17

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2597	Rev E

100		0.00
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100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Cut D2500-3 to length: 84.25"
Use Jig DT8094 to drill pilot holes.
Open to 0.625 diameter using a uni-bit.

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

Handwritten notes:
12-04-17
12/04/17
DP 12-4-17
RG 12-4-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2597

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 204 Web

Start Date: 17/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC2-Inspect Part Finish

0.00

130

QC7

0.00

QC

Memo

Quality Control

4 0 BB 12/04/17

140

Identify as per dwg & Stock Location: LG

0.00

140

Memo

0.00

Packaging

Packaging

4 0 CF 12-4-17

150

QC21- Final Inspection - Work Order Release

0.00

150

Memo

0.00

QC

Quality Control

12/4/19 JF
WLB 12-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

April-17-12 8:48:56 AM

Page 1

Work Order ID: 83304

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Parent Item: D2597

D2597

Parent Item Name: 204 Web

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D98.10.15Eliminated DEO, Changed Dwg
RevisionKS
IPP REV:E ADDED HOLES TO TOOLING 11-09-06 JLM VERIFIED
BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-3-100

Manufactured

No

110

Each

56.0000

1

4

D2500-3-100

**

Ext'n - 1" Beam Web 4"

Location

Loc Qty

Loc Code

LG

56

51957

2

66298

3

79041

51

3

1

Handwritten signature and date: 12-24-17

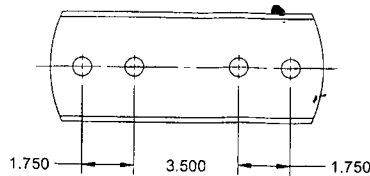
W/O:		WORK ORDER CHANGES					
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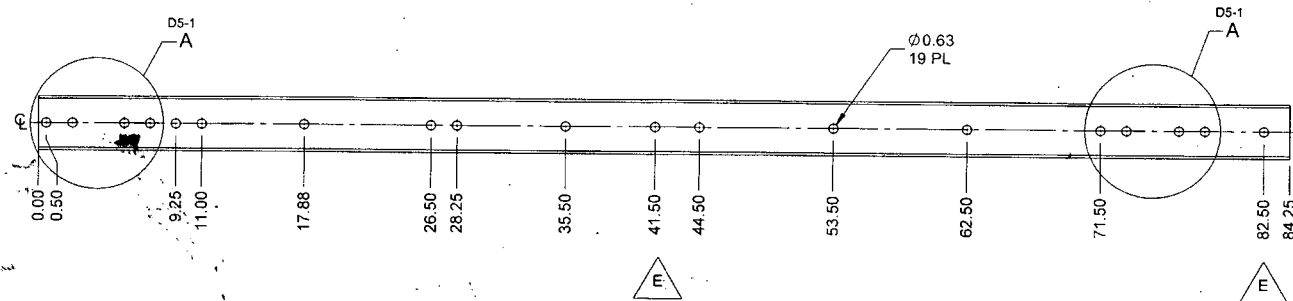


DETAIL A
SCALE 2X C2-1
C7-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 83304 MLJ
12/04/17



D2597 WEB (204)

RELEASED
2011-08-29

NOTES:

- 1) MATERIAL: MANUFACTURED FROM D2500-3-84.25 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.99 lbs

E	ADD HOLES (ZN B5-1, B2-1)	RF	11.06.21
D	INCORPORATED DEC 9097	CP	98.09.14
C	Ø 0.63 WAS Ø 0.56	KE	97.07.23
B	5.75 WAS 0.50	DS	96.10.29
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	MP	DRAWING NO.	REV. E
MFG. APPR.	DS	D2597	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	204 WEB	NTS
DATE	11.06.21	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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